

**METHOD FOR COLD FORGING FLANGE COMPANION**

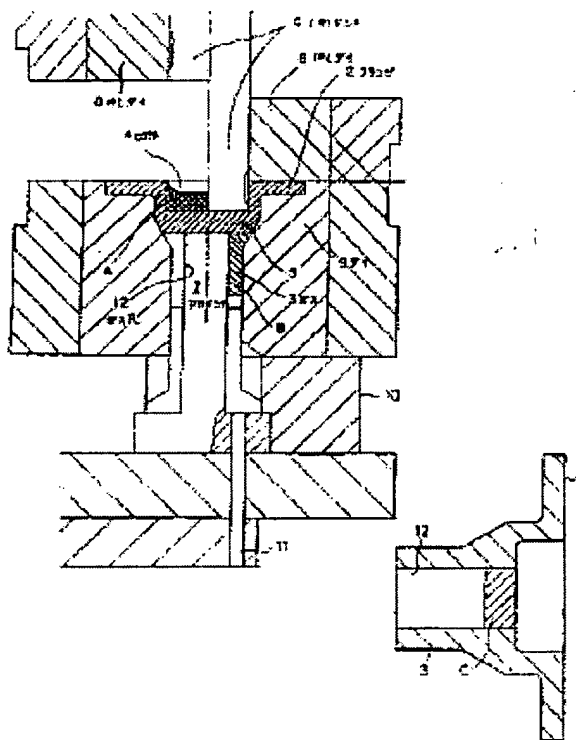
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**Abstract of JP1205844**

**PURPOSE:** To take the balance of a volume at the boss and boss hole forming time and to improve the yield of a material by forming a recessed part at the flange back side in case of the flange cold heading time at the cold forging forming stage of a flange companion.

**CONSTITUTION:** A flange 2 is subjected to cold heading by a rocking press by executing annealing and bonderizing after preforming a material 1 by cutting a material. At this time, a recessed part 4 is formed in advance at the back side of the flange 2 and the body 5 subjected to cold heading of the flange 2 is annealed to execute bonderizing thereon. The clamping by a press die 8 is then executed by putting the body 5 subjected to flange heading into the die 9 of a boss forming die, an upper side punch 6 is pushed in and a boss 3 and boss hole 12 are simultaneously formed by the die 9 and lower side punch 7. At this time, the balance of the volume of the part A to be pushed out and that of the part B of the boss 3 can be taken because the recessed part 4 is formed at the flange back side and the material yield is improved. Thereafter, the C part is subjected to piercing.



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